

Work Order ID 52166

September 17, 2009 10:16:01 AM



PRELIMINARY ISSUE

Page 1

Item ID: D212-725-1-247

Accept



Setup Start



Revision ID: G-PRELIM

Stop



Item Name: Cam



Start Date: 17/09/2009 Start Qty: 1.00

Cust Item ID:

Required Date: 18/09/2009 Req'd Qty: 1.00

Customer:

Reference: *17.09.09.17*

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D212-725-1	G-PRELIM								

100

0.00



Bandsaw

Memo

0.00

MF 09/07/18

1

Jeaspa Bandsaw

Cut blanks 3.250" long

110

0.00



HAAS 1

Memo

0.00

MF 09/09/18

1

HAAS CNC vertical machine #1

Machine as per folio FA843 and DWG

Folio rev: *AA*

Dwg Rev: *A*

Deburr as per Dwg

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Item Name: Cam

Start Date: 17/09/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 18/09/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC2- Inspect parts off machine FAL/FAIB

0.00



QC

Memo

0.00

Quality Control

150

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

160

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

*mt
09/18**Jul 04-09-18**N/A. Jul 09-08-19**1**Q*

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Item ID: D212-725-1-247

Accept



Setup Start



Revision ID: G-PRELIM

Stop



Item Name: Cam

Start Date: 17/09/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 18/09/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170

QC3- Inspect Part Finish

0.00



QC

Quality Control

Memo

0.00

N/A. 9/04.09.18

200

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

Ship to Roberto
in Cal

210

QC21- Final Inspection - Work Order Release

0.00



QC

Quality Control

Memo

0.00

NO COFC OR QC21 FOR THIS PART

POSITIVE RECALL

EFFECTIVE 9/9/17 AUTH

RELEASED _____ DATE _____

Charge to RD0315 SEP

MF 09-09-18

Picklist Print

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Page 1

Work Order ID: 52166



Parent Item: D212-725-1-247RevG-PRELIM



Parent Item Name: Cam

Start Date: 17/09/2009

Required Date: 18/09/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B0.625X02.50 0		Purchased	No			100	f	8.8000	0.3158			



6061-T6 Bar .625 x 2.50

Warehouse

Loc Qty

Loc Code

Location

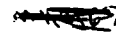
Main Warehouse

MAT

8.8

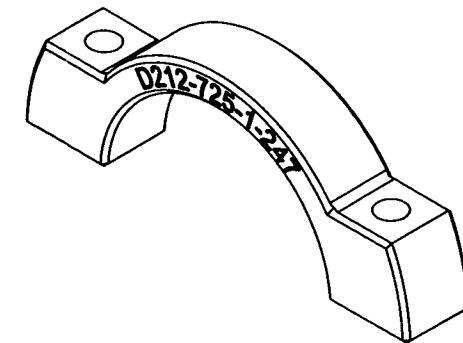
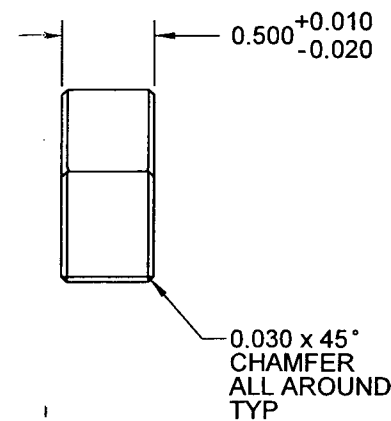
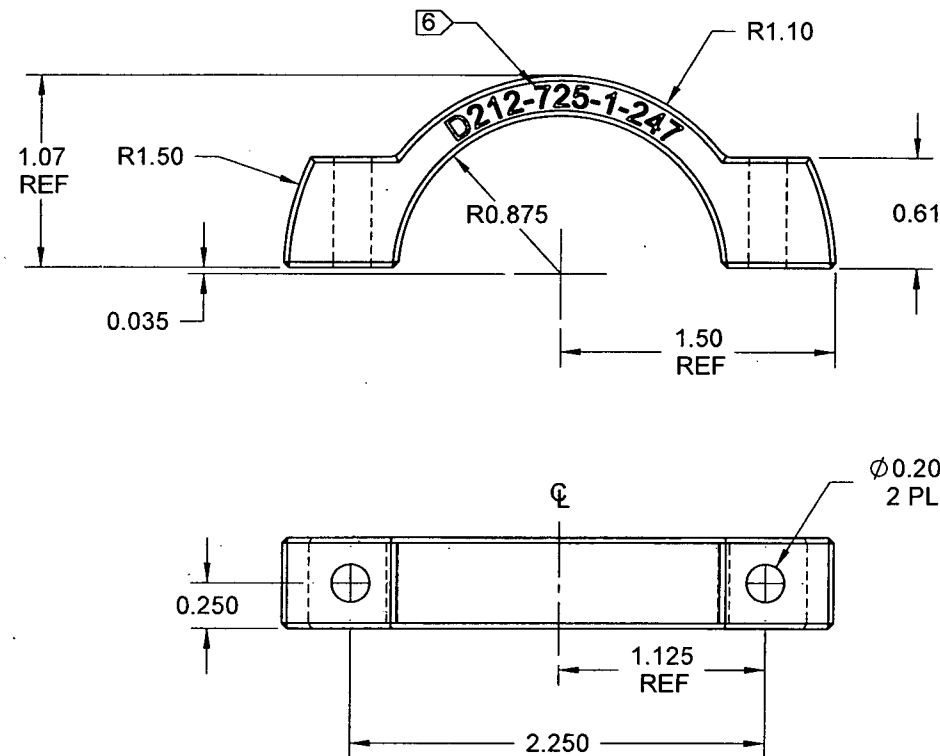
108961

8.8



mt
8/09/18

3158



D212-725-1-247 RETAINER

PRELIMINARY

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF. DART SPEC. M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE WITH DART P/N IN THIS AREA AS SHOWN TO MAX DEPTH
OF 0.015 IN 0.125 HIGH LETTERS WITH A MIN RADIUS TOOL OF 0.015
- 7) WEIGHT: 0.05 lbs

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. G
MFG. APPR.		D212-725-1	SHEET 86 OF 86
APPROVED		TITLE	SCALE
DE APPR.		212S DETAIL PARTS	NTS
DATE	09.09.03	<small>COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	